

Work Order ID 63572

Thursday, November 04, 2010 1:13:58 PM

Page 1

Item ID: D3283-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 11/4/2010 Start Qty: 12.00

Required Date: 11/12/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283

☐ Dwg Rev:

E

☐ Prog Rev:

E

☐ 2-

Deburr if necessary

6061 . 063

10-11-04

16

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-11-04

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10/14/09

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63572

Thursday, November 04, 2010 1:13:58 PM



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Item ID: D3283-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo *****ensure rivet fits in #30 (0.128") holes as per dwg *****	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

N/A 10/11/30

N/A 10/11/30

=> 10/11/30

16 0

W/O:		WORK ORDER CHANGES					
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Work Order ID 63572

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Item ID: D3283-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

16 BR 10-11-30.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 42

0.00

Memo

0.00

10/11/30 [Signature] 160

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 10/11/30 [Signature]
C21011130

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:14:02 PM

Page 1

Work Order ID: 63572



Parent Item: D3283-1

Parent Item Name: Doubler



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP ☐ A ☐ 04.09.28 ☐ New issue ☐ KJ/JLM ☐
IPP Rev:B Now on Waterjet 07-05-28 JLM
IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	41.2340	0.2361	2.982316			
6061-T6 .063 Sheet													
1310-11-29													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT21		41.234							
				113608		41.234				113608			

116

W/O:		WORK ORDER CHANGES					
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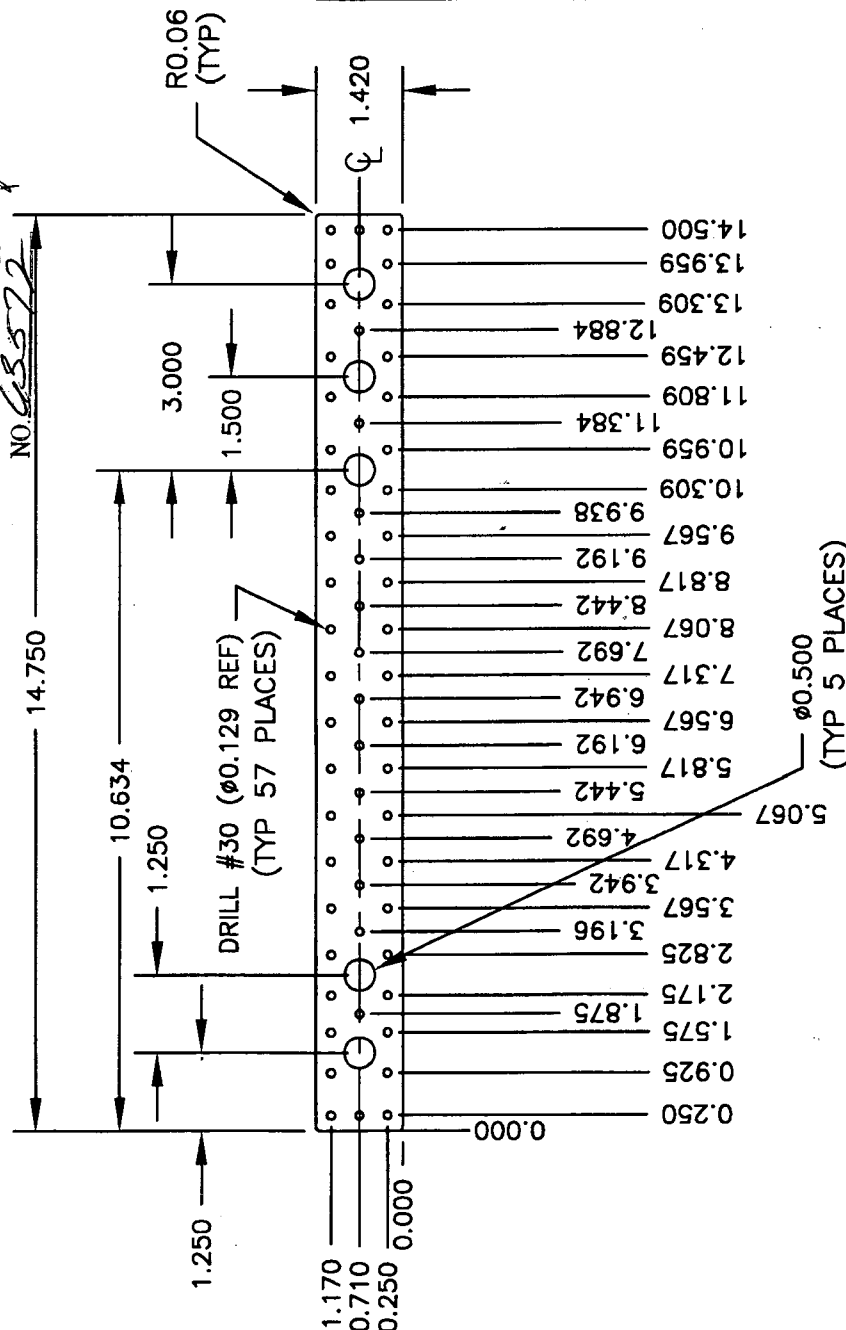
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01	TITLE DOUBLER		SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	

RELEASED
07.08.2004
PER ECN 959

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63572*

**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4:1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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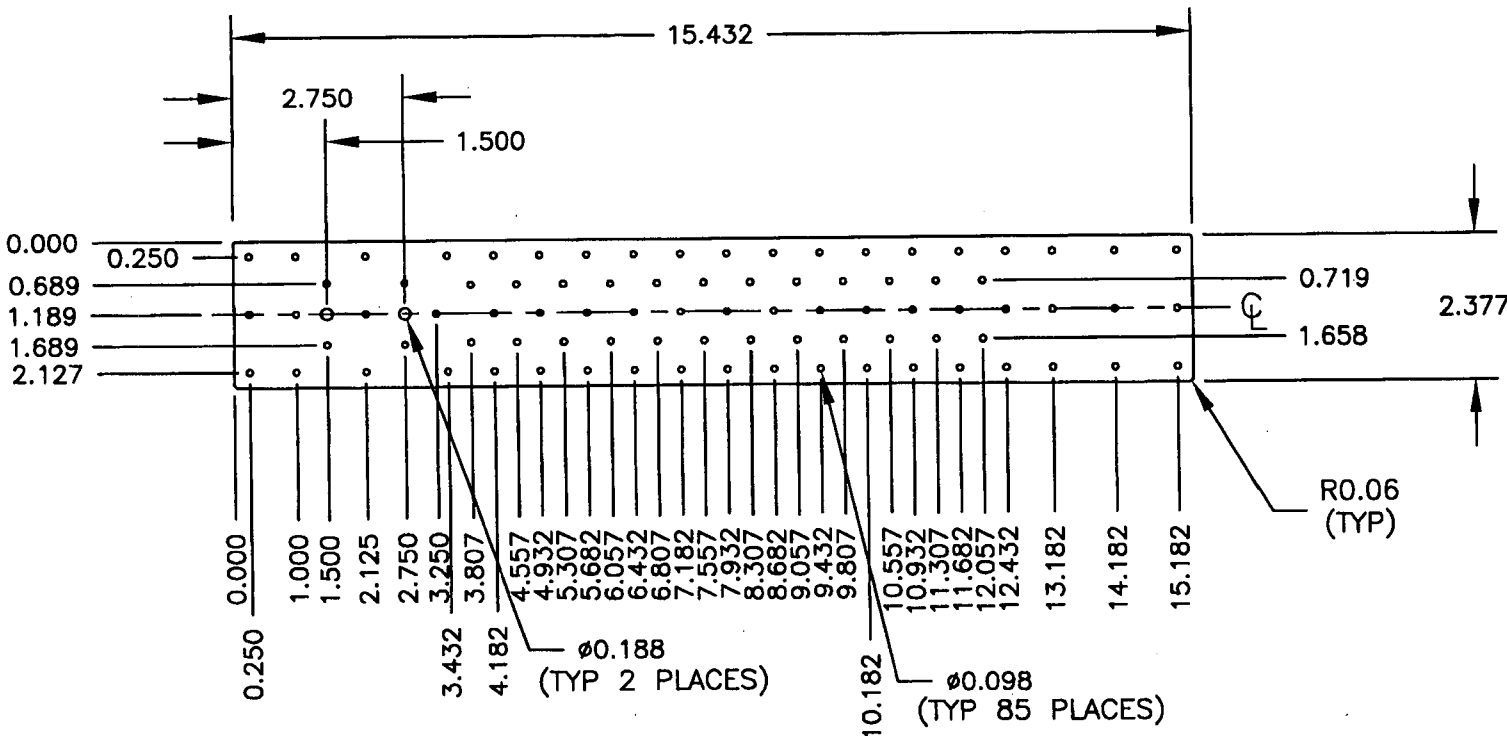
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED <i>GP</i>	APPROVED <i>SL</i>	DRAWING NO.	PORT HADLOCK, WA
		D3283	REV. E
DATE	TITLE	SHEET 2 OF 2	
07.06.01	DOUBLER	SCALE	
		1:3	

RELEASED
07-08-2004
PER ECN 969

w/o 43572



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries